

Work Order ID 83574

83574

Page 1

Thursday, April 19, 2012 3:42:50 PM

Item ID: D350-604-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rear Locker Extender

Start Date: 4/19/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/18/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: *[Signature]*

Date: 12-4-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|--------------|--------------|
| D2273 | <i>PE</i> |
| D350-604-041 | <i>B</i> |

100

0.00

100

DC

Document Control

DOCUMENT CONTROL *[Signature]*

Memo

Photocopy bluefile and create labels per PPP D350-604-041

0.00

(DAS 16)

CHG004

[Signature] MLJ 12-9-25

110

0.00

110

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: *10795 17548*

Description: D350-604-041 Rear locker extender.

Supplier: Delastek.

Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B

4 x 2600-LW Retaining washers - Ship to Delastek B

101287

122335

121524

CL 12/04/23 (4)
CL 12/09/12 (1)

28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 83574

Thursday, April 19, 2012 3:42:51 PM

83574

Page 2

Item ID: D350-604-041

Accept

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Revision ID:

Stop ***NS2***

Item Name: Rear Locker Extender

Start Date: 4/19/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/18/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | Receive & Inspect for Damage & Mat'l Certs | 0.00 | | | | | | | |
| *120* | Packaging | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Ensure a copy of Certification of Conformity and process sheet from Delastek is attached. | | | | | | | | |
| 130 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | Check hole locations to template. DT 8824 Check process sheet and audit. | | | | | | | | |
| 140 | | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | INSTALL DECALS AS PER DWG | | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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Page 3

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

DAS
16
9-10 12/09/25

160

Packaging

0.00

160

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-604-041

Location: _____

PPP Rev: _____

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/09/25

12/09/25

ME
12-09-25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, April 19, 2012 3:42:55 PM

Page 1

Work Order ID: 83574

83574

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 4/19/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF IPP REV:R
12.02.07 AS PER ECN12-521 DD verf:JLM IPP REV:S 12.04.04
AS PER DWG REV.B DD VERF:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D2269

Manufactured No

Each 28.0000

1

D2269

Decal

**

B86944 JD

Location

Loc Qty

Loc Code

ST007

20

80011

20

ST009

8

78920

8

2600-6

Purchased

No

110

Each

131.0000

4

4

2600-6

Camlock Stud

**

CL1210912

Location

Loc Qty

Loc Code

ST380

36

120077

36

ST381

95

121287

95

2600-LW

Purchased

No

110

Each

111.0000

4

4

2600-1 W

Camloc Retaining Washer

**

CL12109112

Location

Loc Qty

Loc Code

ST381

100

121287

100

ST398

11

120648

11

122452
mt21521 x 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 2

Thursday, April 19, 2012 3:42:55 PM

Work Order ID: 83574

83574

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 4/19/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

D350-604-041P

Purchased

No

110

Each

0.0000

1

1

D350-604-041P

Rear Locker Extender

D2268

Manufactured

No

140

Each

33.0000

1

1

D2268

Decal

Location

Loc Qty

Loc Code

ST007

20

80010

20

ST009

13

69592

2

78908

11

Thursday, April 19, 2012 3:42:55 PM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

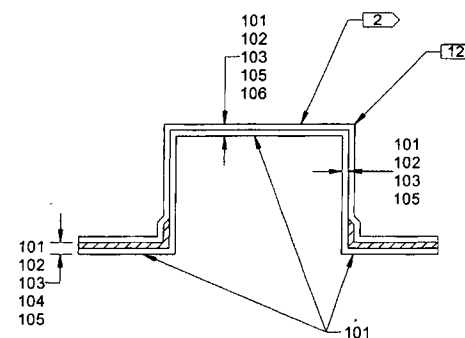
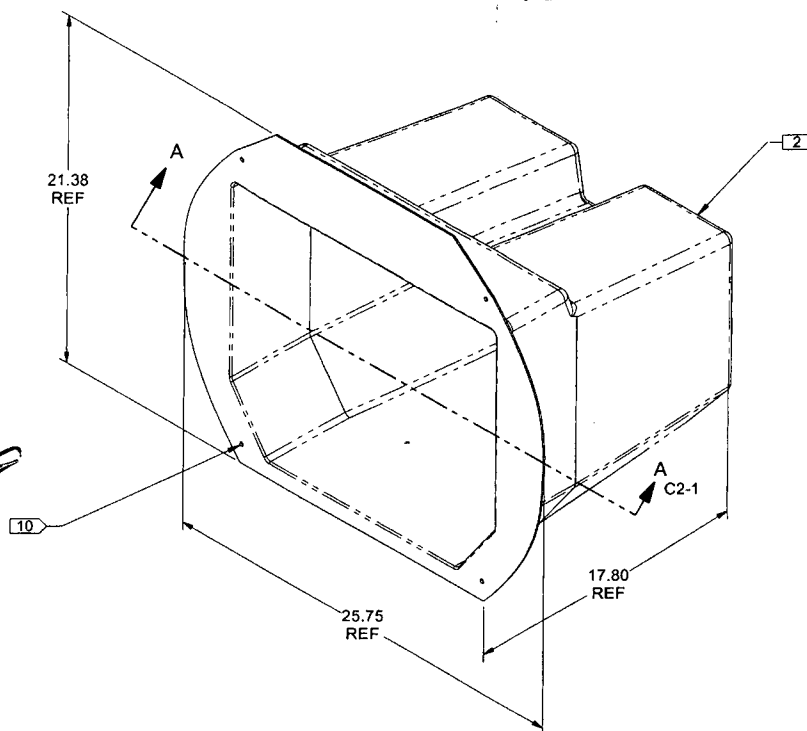
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83574

12-09-19



SECTION A-A
C4-1

RELEASED
2012-03-29

NOTES:

1) MATERIALS:

RESIN: DERAKANE 470-36/411/510A40
FIBRE: 9 oz = 9.7 oz 7781 WEAVE "S" GLASS
18 oz = 18.0 oz ROVING "E" GLASS

2) FINISH: FINISH THIS SURFACE WITH DUPONT GREY PRIMER LE 3404-S/LE 1175-S Δ

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1

7) WEIGHT: 7.75 lbs

8) LAMINATE PER DART QSI 006, LAMINATION SCHEDULE PER THIS DRAWING.

9) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACUUM

10) TRIM & DRILL PER DT8020. OPEN HOLES TO \varnothing 0.257 (4 PLACES)

11) CONSTRUCTION:

101-WHITE GLOSS GELCOAT # GEL 2330PAWK745 TO MIN THICKNESS OF 0.020

102-9 oz ALL OVER

103-18 oz ALL OVER

104-18 oz REINFORCE FRONT FLANGE EXTENDING 2" ON SIDES

105-9 oz ALL OVER

106-PEEL PLY

12) MATTE TO HOLD DOWN CORNERS AS REQUIRED

D2273 REAR LOCKER EXTENDER

| | | | |
|------------|--|---|--------------|
| F | PRIMER LE 3404-S/LE 1175-S WAS 1144-S, ZN A6-1 | DC | 12.02.27 |
| E | CHANGED SURFACE FINISH FROM 944W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1. UPDATED DWG TO CURRENT STANDARDS. | DC | 12.02.02 |
| D | REMOVE EPOCAST, ADD SURFACE FINISH | CP | 02.04.01 |
| C | CLARIFY MATERIAL, LAYUP, AND TOOLING | RF | 02.01.30 |
| B | RE-DRAWN | MM | 98.05.27 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | JB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | DC | | |
| CHECKED | DC | DRAWING NO. | REV. F |
| MFG. APPR. | DC | D2273 | SHEET 1 OF 1 |
| APPROVED | DC | TITLE | SCALE |
| DE APPR. | DC | 350 REAR LOCKER EXTENDER | NTS |
| DATE | 12.02.27 | <small>COPYRIGHT © 1988 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Linda Lacelle

From: dshepherd@dartaero.com
Sent: April-03-12 1:38 PM
To: Daniel Campbell; 'Linda Lacelle'
Cc: Harvey Siemens; Chantal Lavoie
Subject: Re: ECN D2273

Dan,

I think Delastek is confused. Leave the dwgs for now ... I don't care whether we use Rev E primer or Rev F primer ... My understanding is that your Rev F dwg represents what is procurable going forward.

David

Sent from my BlackBerry device on the Rogers Wireless Network

From: "Daniel Campbell" <dcampbell@dartaero.com>
Date: Tue, 3 Apr 2012 10:42:39 -0600
To: 'Linda Lacelle' <llacelle@dartaero.com>; <dshepherd@dartaero.com>
Cc: Harvey Siemens <hsiemens@dartaero.com>; Chantal Lavoie <clavoie@dartaero.com>
Subject: RE: ECN D2273

Hi,

I'm a little confused about this.

I thought we had checked back in Feb. and the 7704-S was discontinued and replaced with LE-3404-S / LE1175-S ?

Anyway, I can go back and update the following to call out 7704-S:

D604-350

1. D2273
2. ICA-D350-604

D605-206

1. D2566
2. ICA-D605-206

I'm not sure if David is flying today - we might have to wait for him to weigh in.

Thanks,
Dan

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: April-03-12 10:00 AM
To: dshepherd@dartaero.com; Daniel Campbell
Subject: FW: ECN D2273

From: Jocelyne Laurin [<mailto:JLaurin@delastek.com>]
Sent: April-03-12 11:30 AM
To: Linda Lacelle
Cc: 'Chantal Lavoie'; Céline Audet
Subject: ECN D2273

Hello Linda,

For the Gel Coat we are presently using N° 2330PAWK745, Gel Coat Polycore Fireblock and for the primer Dupont Primer N° 7704S. Thank you and have a nice day.

Jocelyne Laurin

Agente Service à la clientèle/Customer Service Agent

DELASTEK INC.

jlaurin@delastek.com

De : Linda Lacelle [<mailto:llacelle@dartaero.com>]

Envoyé : 2 avril 2012 14:54

A : Jocelyne Laurin; 'Chantal Lavoie'

Cc : David Paradis; Céline Audet

Objet : RE: ECN D2273

Importance : Haute

Jocelyne,

This is the current primer you are using. We need to understand exactly what you are currently using. Please DO NOT stop production on the parts to ship this Thursday.

L

From: Jocelyne Laurin [<mailto:JLaurin@delastek.com>]

Sent: April-02-12 10:18 AM

To: 'Chantal Lavoie'; Linda Lacelle

Cc: David Paradis; Céline Audet

Subject: ECN D2273

Importance: High

Hello Chantal,

Before we can ship the rearlockers at rev. F, (for order attached), we have to analyse the implications, so the confirmed dates no longer stand, since they were for revision E. As soon as the analysis is completed we will forward a new quote (if applicable) as well as the new delivery dates, unless you want them at Rev. E. Please advise ASAP as they are being produced at the moment. Thank you so much and have a nice day.

Jocelyne Laurin

Agente Service à la clientèle/Customer Service Agent

DELASTEK INC.

jlaurin@delastek.com

De : Chantal Lavoie [<mailto:clavoie@dartaero.com>]

Envoyé : 30 mars 2012 10:38

À : Jocelyne Laurin

Cc : Lacelle, Linda

Objet : ECN D2273

Hi Jocelyne,

Please see attached for new revision for rearlocker they are now at rev. F.

Thanks

Chantal

No virus found in this message.

Checked by AVG - www.avg.com

Version: 2012.0.1913 / Virus Database: 2114/4912 - Release Date: 04/03/12

**Certificate of Conformance****Solve Composites****29 Distribution Way****Plattsburgh, New York, 12901****USA****Dart Aerospace Order Number: 17583**

P/O: 17548 CD 12/09/24

Part Number: D2273**Quantity: 1****Drawing Number: D2273, DT8020****Serial Number (s): 0028, 0029****Date: September 24, 2012****Non-Conformances: None**

This is to certify that the parts identified above conform to all applicable drawings and/or specifications as evidenced by reports on file, and that all other purchase order and quality requirements have been met.

Jerry Reyell**Project Manager****Solve Composites**

B83574